Calculation of production per minute

a) **Length of one Lead (mm) × Track R.P.M. = mmperminute**

Track R·P·M.

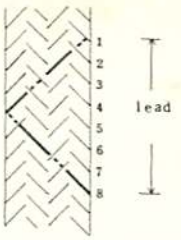
Flat Braid .....

$$\frac{\text{Horn Gear R.P.M.}}{\text{Machine Spindle Number} \div 2}$$

Round Braid .....

$$\frac{\text{Horn Gear R.P.M.}}{\text{Machine Spindle Number} \div 4}$$

ROUND



b) $$\frac{\text{Horn Gear R.P.M.} \times 2}{\text{stitches (or Picks) per inch}} = \text{Inches per minute}$$

Remarks: —

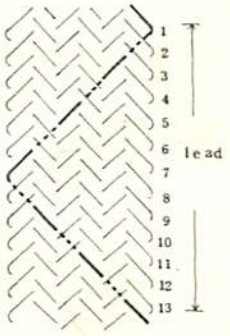
※ Revolution ratio of Horn Gear and Handle

3″ Horn Gear Machine (model 101, 102, ST) ..... 1 : 1

4″ Horn Gear Machine (model 104, STL, 2D) ..... 1 : 0.8

※ Length of one lead in round braid = Braid diameter × 2.19 (In case 35° braid angle)

FLAT



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